

Date: Wednesday, 1/31/2007 2:18:38 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	LID PRO ARM ASSEMBLY (SHORT)				
Job Number	30547	Part Number	D2332041				
Estimate Number	10258	Drawing Number	D2332 REV C1				
P.O. Number	N/A	Project Number	N/A				
This Issue	1/31/2007	Type	SMALL /MED FAB				
Prsht Rev.	NC	Drawing Revision	C1				
First Issue	N/A	Material	N/A				
Previous Run	29134	Due Date	2/20/2007				
Written By						Qty: 20	Um: Each
Checked & Approved By	2007.02.01						
Comment	Est: B 02.08.12 Re-format; Incorporated D2332-13-11-7-5 K						
J/RF							
Additional Product							
Job Number:							
Seq. #:	Machine Or Operation:	Description :					
1.0	M304TR1000WO49	304 RD Tube 1.0" x .049W					
							✓
Comment: Qty.: 0 f(s)/Unit Total : 9 f(s)		M103240					
Material: 1.000" OD x 0.049" wall SS Tube (Seamless)		M103240					
2.0	M304R250	1/4" 304 SS Roundbar					
							✓
Comment: Qty.: 0 f(s)/Unit Total : 2 f(s)		M17931 X2' 2007/02/21					
Material: Ø0.250" 304SS Rod							
Batch <u>M17931 X2'</u>							
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1					
							✓
Comment: SMALL & MEDIUM FAB RESOURCE 1							
1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar X20							
2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin							
3-Deburr 2007/02/22							
4.0	M304TR0500W035	304 RD Tube .500 x .035W					
							✓
Comment: Qty.: 1 f(s)/Unit Total : 24 f(s)		M102742 X11 2007/02/22					
304 RD Tube .500 x .035W							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 30547		Part Number: D2332041	
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
5.0	BRAKE NC	NC BRAKE 	
Comment: NC BRAKE		<i>07/02/13 20 ASSY</i>	
Punch or form to length as per Dwg D2332 (D2332-11) using DT8012 (Note: Make (2) D2332-11 Prop Arms per assembly.)		<i>40</i>	
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 	
Comment: LARGE FABRICATION RESOURCE 1		<i>ml 07/02/21 (x20)</i>	
1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)		<i>PD/FC 07-02-22 (20)</i>	
2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)		<i>PD/FC 07-02-22 (20)</i>	
A/R SS Rod Batch: <i>M102756</i>		<i>PD/FC 07-02-22 (20)</i>	
7.0	QC9	VISUAL WELDING INSPECTION 	
Comment: VISUAL WELDING INSPECTION		<i>M 07/02/22 (20)</i>	
8.0	QC5	INSPECT WORK TO CURRENT STEP 	
Comment: INSPECT WORK TO CURRENT STEP		<i>M 07/02/22 (20)</i>	
9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 	
Comment: SMALL & MEDIUM FAB RESOURCE 1		<i>SP 07/03/13 (20)</i>	
1-Tumble		<i>SP 07/03/13 (20)</i>	
2-Assemble as per Dwg D2332		<i>MF. 07-03-13 (20)</i>	
10.0	AN44A	Bolt 	
Comment: Qty.: 1 Each(s)/Unit Total : 20 Each(s)			
Pick:			
Qty	Part Number	Description	Batch
1	AN4-4A	Bolt	<i>M101291</i>
		<i>MF. 07-03-13</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 30547		Part Number: D2332041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
11.0	AN960JD416L 	Washer 
Comment: Qty.: 3 Each(s)/Unit Total : 60 Each(s)		
Pick:		
Qty	Part Number	Description
3	AN960JD416L	Washer
		Batch <u>M101a31</u>
MF. 07-03-13		
12.0	MS21042L4 	Nut 
Comment: Qty.: 1 Each(s)/Unit Total : 20 Each(s)		
Pick:		
Qty	Part Number	Description
1	MS21042L4	Nut (or -4)
		Batch <u>m103349</u>
MF. 07-03-13		
13.0	QC5 	INSPECT WORK TO CURRENT STEP <u>2070314 = 20</u> 
Comment: INSPECT WORK TO CURRENT STEP		
14.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Q01</u>		
15.0	QC21 	FINAL INSPECTION/W/O RELEASE  <u>07/03/15 (Q0)</u> <u>22</u>
Comment: FINAL INSPECTION/W/O RELEASE		<u>07/03/15</u>
Job Completion 		<u>07/03/16</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

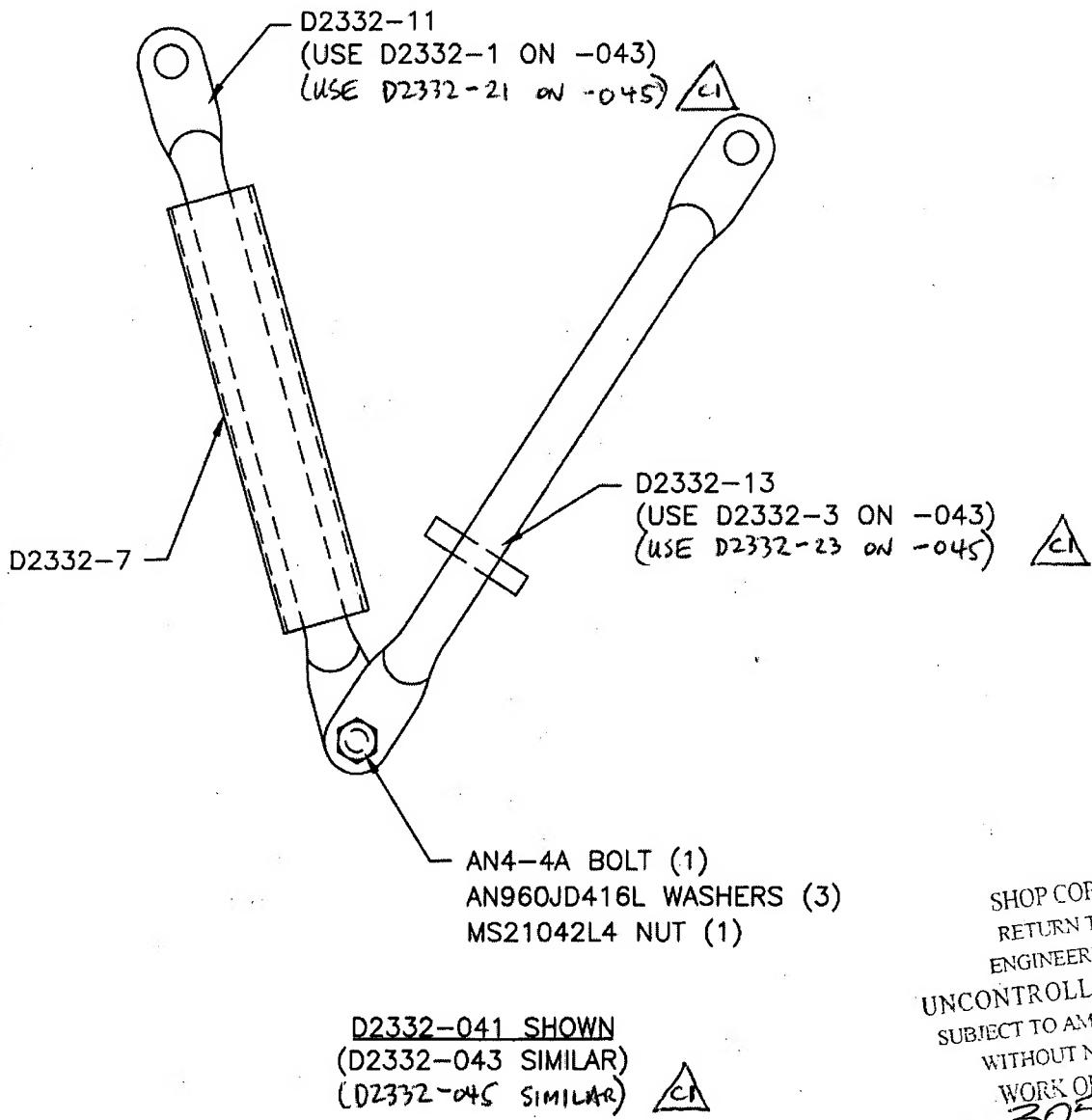
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

COPY ISSUED

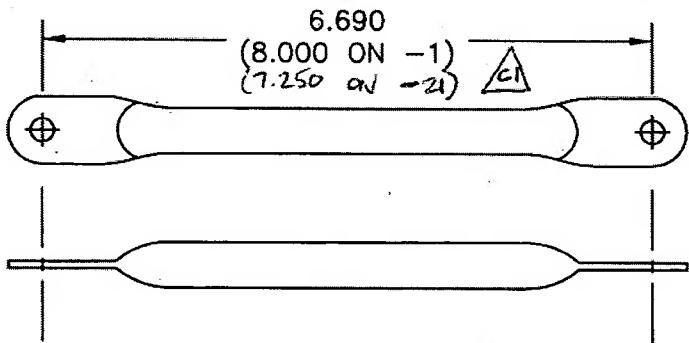
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2332	SHEET 1 OF 2
DATE		TITLE	SCALE
03.07.03		LOD PROP ASSEMBLY	NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04

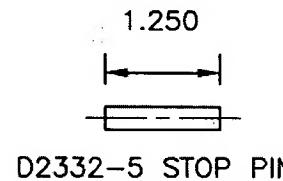
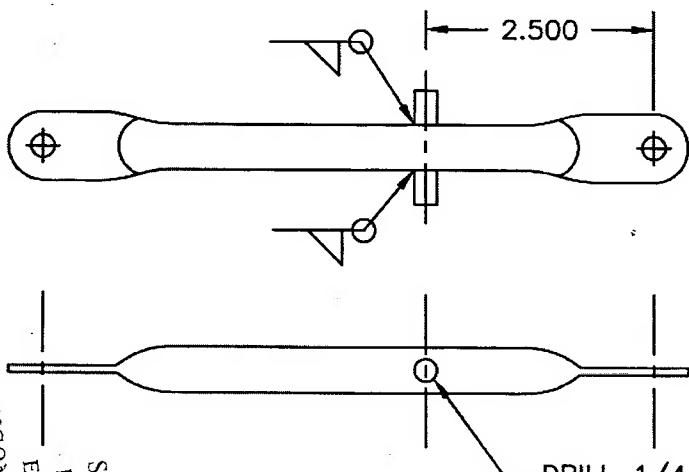
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RELEASED
03.07.04



D2332-11 PROP
(D2332-1 SIMILAR)



D2332-7 LOCKING COLLAR

DART

3 COPY ISSUED
03.07.03

DESIGN	DRAWN BY	DART AEROSPACE LTD
C	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	APPROVED	DRAWING NO.
03.07.03	<i>[Signature]</i>	D2332

MADE - 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035 0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250 1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049	MADE - 0.43 OD x 0.035 WALL SS TUBE (D2332-1/-13) M304TR0.430W.035 0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250 1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
REV. C SHEET 2 OF 2	REV. C SHEET 2 OF 2

D2332-13
M/F D2332-11 & D2332-5

D2332-3 SIMILAR - M/F D2332-1 & D2332-5

D2332-23 SIMILAR - M/F D2332-21 & D2332-5

CI

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NO 30541
VOIS ORDER

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

